

What is claimed is:

1. A casting riser pan for use in casting a concrete wall of a concrete structure with an access opening therethrough and a cover for the access opening, comprising:
 - a wall having an top portion and a bottom portion;
 - said wall defining the periphery of a concrete cover for the opening;
 - said wall including a single orientation portion to form an orientation element adapted to orient the concrete cover relative to the riser pan.
2. A casting riser pan as claimed in claim 1, wherein said wall is generally annular.
3. A casting riser pan as claimed in claim 1, wherein said wall is tapered radially outward from said bottom portion to said top portion.
4. A casting riser pan as claimed in claim 1, wherein said wall further includes an upper portion and a lower portion and a transverse shoulder extending radially inward between said upper portion and said lower portion.
5. A casting riser pan as claimed in claim 3, wherein said wall further includes an upper portion and a lower portion and a transverse shoulder extending radially inward between said upper portion and said lower portion.
6. A casting riser pan as claimed in claim 1, wherein said orientation element comprises a protrusion extending radially inward defining a recess in the concrete cover.
7. A casting riser pan as claimed in claim 6, wherein said protrusion has a top portion and a bottom portion, said top portion of said protrusion being narrower than said bottom portion of said protrusion.

8. A casting riser pan as claimed in claim 1, wherein said orientation element comprises an indentation in said wall defining a protrusion from the concrete cover.
9. A casting riser pan as claimed in claim 8, wherein said indentation has a top portion and a bottom portion, said top portion of said indentation being wider than said bottom portion of said indentation.
10. A casting riser pan as claimed in claim 1, further comprising a continuous securement element extending radially inward from said bottom portion of said wall, said continuous securement element adapted to be connected to a casting mold.
11. A casting riser pan as claimed in claim 10, wherein said continuous securement element further includes a weakened region connecting said continuous securement element to said bottom edge portion.
12. A casting riser pan as claimed in claim 10, wherein said continuous securement element further includes one or more attachment holes adapted to receive a fastener for securing said continuous securement element to the casting mold.
13. The combination of a casting riser pan as claimed in claim 12 and at least one fastener inserted through one of said attachment holes and adapted to be attached to the casting mold, said fastener having a head portion with a diameter generally larger than the diameter of said attachment holes and a shaft portion having a diameter generally smaller than the diameter of said holes.
14. A casting riser pan as claimed in claim 1, further comprising an end portion adapted to be received by a stackable riser section.
15. A casting riser pan as claimed in claim 14, further comprising an end portion adapted to be received by a stackable riser section.
16. A casting riser pan as claimed in claim 15, wherein said end portion includes an axially extending upstanding wall.

17. The combination of the casting riser pan as claimed in claim 14 and a stackable riser.
18. The combination of the casting riser pan as claimed in claim 1 and a concrete cover.
19. A casting riser pan for use in casting a concrete wall of a concrete structure with an access opening therethrough and a concrete cover for the access opening, comprising:
 - an inner wall having an top portion and a bottom portion;
 - an outer wall;
 - said inner wall defining the outer periphery of the concrete cover for the opening; and
 - said outer wall connected to said inner wall at said top portion.
20. A casting riser pan as claimed in claim 19, wherein said outer wall depends angularly outward from said inner wall.
21. A casting riser pan as claimed in claim 19, wherein said inner wall is generally annular.
22. A casting riser pan as claimed in claim 19, wherein said outer wall is generally annular.
23. A casting riser pan as claimed in claim 19, wherein said inner wall is tapered radially outward from said bottom portion to said top portion.
24. A casting riser pan as claimed in claim 19, wherein said inner wall further includes an upper portion and a lower portion and a transverse shoulder extending radially inward between said upper portion and said lower portion.
25. A casting riser pan as claimed in claim 23, wherein said inner wall further includes an upper portion and a lower portion and a transverse shoulder extending radially inward between said upper portion and said lower portion.

26. A casting riser pan as claimed in claim 19, wherein said top portion of said inner wall further comprises a substantially transverse shoulder extending radially outward from said inner wall, said outer wall connected to said inner wall at said substantially transverse shoulder.
27. A casting riser pan as claimed in claim 19, said inner wall including a single orientation portion to form an orientation element adapted to orient the concrete cover relative to the riser pan.
28. A casting riser pan as claimed in claim 27, wherein said orientation element comprises a protrusion extending radially inward defining a recess in the concrete cover.
29. A casting riser pan as claimed in claim 28, wherein said protrusion has a top portion and a bottom portion, said top portion of said protrusion being narrower than said bottom portion of said protrusion.
30. A casting riser pan as claimed in claim 27, wherein said orientation element comprises an indentation in said inner wall defining a protrusion from the concrete cover.
31. A casting riser pan as claimed in claim 30, wherein said indentation has a top portion and a bottom portion, said top portion of said indentation being wider than said bottom portion of said indentation.
32. A casting riser pan as claimed in claim 19, further comprising a continuous securement element extending radially inward from said bottom portion of said inner wall, said continuous securement element adapted to be connected to a casting mold.
33. A casting riser pan as claimed in claim 32, wherein said continuous securement element further includes a weakened region connecting said continuous securement element to said bottom edge portion.
34. A casting riser pan as claimed in claim 32, wherein said continuous securement element further includes one or more holes adapted to receive a fastener for securing said continuous securement element to the casting mold.

35. The combination of a casting riser pan as claimed in claim 34 and at least one fastener inserted through one of said attachment holes and adapted to be attached to the casting mold, said fastener having a head portion with a diameter generally larger than the diameter of said attachment holes and a shaft portion having a diameter generally smaller than the diameter of said holes.
36. A casting riser pan as claimed in claim 19, further comprising an anchor element extending radially outward from said outer wall, said anchor element adapted to be embedded in the concrete wall.
37. A casting riser pan as claimed in claim 35, wherein said anchor element is generally annular.
38. A casting riser pan as claimed in claim 19, further comprising a plurality of ribs connected to said outer wall and said inner wall.
39. A casting riser pan as claimed in claim 19, further comprising an end portion adapted to be received by a stackable riser section.
40. A casting riser pan as claimed in claim 39, wherein said end portion includes an axially extending upstanding wall.
41. The combination of the casting riser pan as claimed in claim 39 and a stackable riser.
42. The combination of the casting riser pan as claimed in claim 19 and a concrete cover.